

Date: Friday, 27/02/2009 10:35:45 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE, OUTBOARD, LH, 206
Job Number	: 46097		
Estimate Number	: 10818		
P.O. Number	:	Part Number	: D26651
This Issue	: 27/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D2665 REV.D
First Issue	: / /	Project Number	: N/A
Previous Run	: 44282	Drawing Revision	: D
	Type : MACHINED PARTS	Material	:
Written By	:	Due Date	: 11/03/2009
Checked & Approved By	: <u>JUD 09.02.27</u>	Qty:	8 Um: Each
Comment	: Est: C 00.11.01 Removed P/O for Powder Coat - in house processEC Est Rev:D As per Rev'D 07-03-19 JLM		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101003

Saddle Billet, 7075



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Cut Size 2.0" x 6.25" x 7.88"

Grain Along Long 7.88 Length

Batch no:

B31387 X 4 PCS

B25346 X 1 PCS

B34873-2 X 2 PCS J.F. 09/03/04 (7)

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program batch number.

1- Inspect part number and batch number are programmed correctly.

2- Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet

3- Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet

4- Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet

5- Deburr

J.F.

09/03/09 (7)

3.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.F. / JIP 09/03/10

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / JIP 09/03/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 27/02/2009 10:35:46 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 46097

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

N.A 09/03/11

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BP 09-03-11

(7)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1110 939.

START TIME:

9:25

OVEN TEMPERATURE:

330

FINISH TIME:

9:55

BP 09-02-12

(7)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

09-03-12

(7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

436

9/3/13

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 09/03/16

Job Completion



12 09.03.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 46097	
Description: 206 Saddle, Outboard, Left side		Part Number: D2665-1	
Inspection Dwg: D2665 Rev. D		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.106	0.107	0.106	0.1065		
B	0.100	0.140		0.119	0.120	0.115	0.122		
C	1.125	1.145		1.132	1.132	1.131	1.1325		
D	0.615	0.685		0.652	0.652	0.652	0.6600		
E	0.240	0.260		0.248	0.249	0.249	0.250		
F	1.313	1.343		1.321	1.321	1.321	1.3175		
G	0.210	0.230		0.214	0.214	0.213	0.2135		
H	0.100	0.180		0.133	0.132	0.133	0.135		
I	2.470	2.510		2.493	2.493	2.493	2.492		
J	1.565	1.585		1.571	1.572	1.570	1.572		
K	0.235	0.240		0.238	0.238	0.237	0.237		
L	0.100	0.120		0.119	0.119	0.120	0.111		
M	0.990	1.010		1.008	1.0065	1.0065	1.006		
N	0.510	0.515		0.510	0.510	0.510	0.510		
O	5.990	6.010		6.000	6.000	6.000	6.003		
P	1.245	1.255		1.251	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.509		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.316	0.316	0.316	0.316		
T	2.495	2.505		2.499	2.499	2.499	2.496		
U	1.357	1.367		1.363	1.363	1.363	1.362		
V	0.787	0.807		0.799	0.799	0.798	0.795		
W	0.540	0.560		0.552	0.552	0.552	0.550		
X	1.674	1.684		1.680	1.680	1.680	1.679		
Y	0.257	0.262		0.259	0.259	0.259	0.257		
Z	0.912	0.932		0.924	0.925	0.924	0.910		
AA	0.490	0.510		0.502	0.502	0.504	0.501		
AB	0.178	0.198		0.188	0.188	0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.
Date:	09/03/09

Audited by:	HA
Date:	09/03/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46007
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				5	6	7	4		
A	0.100	0.140		0.106	0.105	0.107			
B	0.100	0.140		0.120	0.120	0.120			
C	1.125	1.145		1.1305	1.1305	1.1335			
D	0.615	0.685		0.660	0.660	0.660			
E	0.240	0.260		0.249	0.250	0.250			
F	1.313	1.343		1.3175	1.316	1.317			
G	0.210	0.230		0.213	0.212	0.214			
H	0.100	0.180		0.130	0.130	0.130			
I	2.470	2.510		2.490	2.493	2.492			
J	1.565	1.585		1.5695	1.570	1.572			
K	0.235	0.240		0.237	0.2375	0.238			
L	0.100	0.120		0.110	0.112	0.113			
M	0.990	1.010		1.006	1.006	1.0065			
N	0.510	0.515		0.510	0.510	0.510			
O	5.990	6.010		6.003	6.003	6.003			
P	1.245	1.255		1.250	1.250	1.250			
Q	2.495	2.505		2.500	2.500	2.500			
R	0.313	0.318		0.314	0.314	0.314			
S	0.315	0.322		0.316	0.316	0.316			
T	2.495	2.505		2.497	2.497	2.497			
U	1.357	1.367		1.362	1.362	1.362			
V	0.787	0.807		0.794	0.794	0.794			
W	0.540	0.560		0.549	0.548	0.548			
X	1.674	1.684		1.679	1.679	1.679			
Y	0.257	0.262		0.257	0.257	0.257			
Z	0.912	0.932		0.920	0.920	0.920			
AA	0.490	0.510		0.503	0.503	0.504			
AB	0.178	0.198		0.188	0.188	0.188			
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJP
Date: 09/03/10

Audited by: K.A
Date: 09/03/11

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

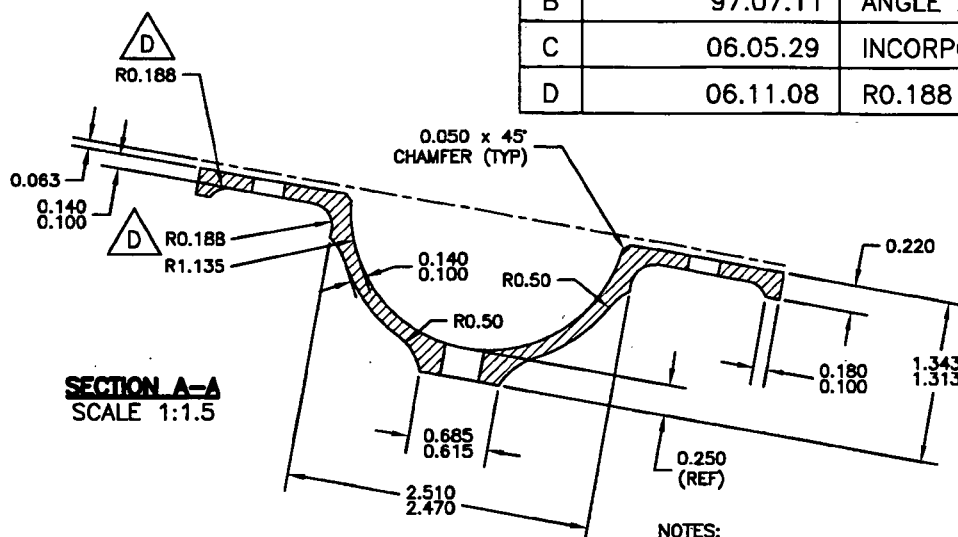
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

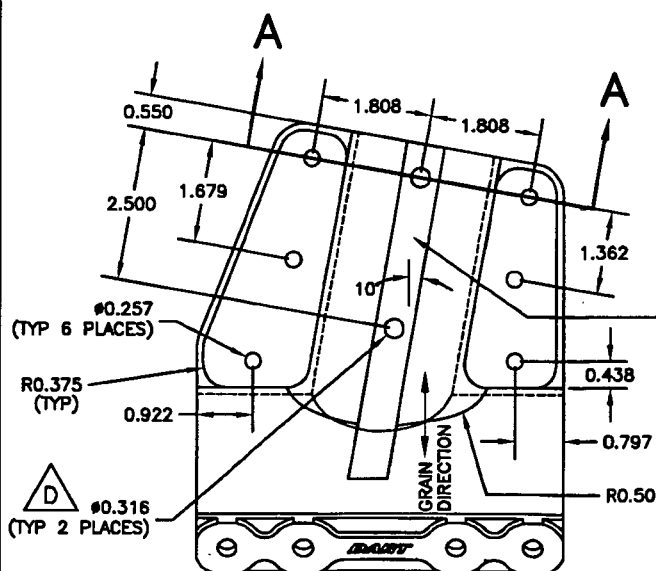
DART

DESIGN	<i>PH</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>PH</i>	DRAWING NO.	REV. D
				D2665	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE FWD OUTSIDE HIGH	1:3
A	97.03.25			NEW ISSUE	
B	97.07.11			ANGLE AND NOTES ADDED	
C	06.05.29			INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08			R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	

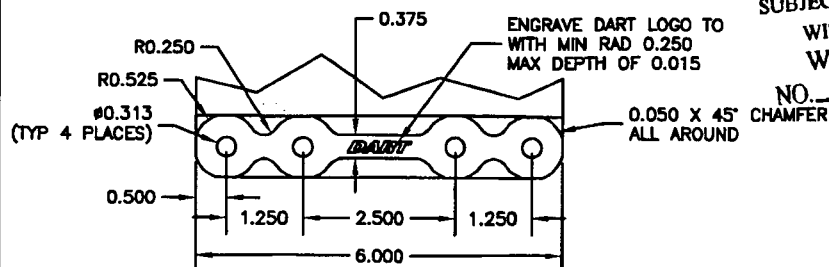


RELEASED

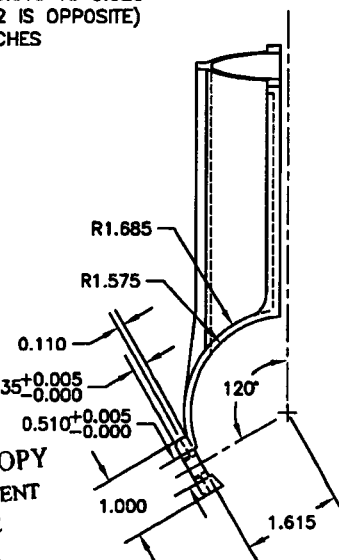
07.02.12



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46097

**D2665-1 SADDLE FWD OUTSIDE HIGH**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng./ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries